

ABSTRACT

A refrigerant assembly includes a block-type thermostatic expansion valve and one or more refrigerant tubes. The body of the block valve has a port extending inwardly from one surface, and a refrigerant tube is received in the port. The refrigerant tube
5 includes an annular bead, which is closely received within a counterbore coaxial with the bore. The surface of the body surrounding the counterbore is then mechanically deformed, preferably by staking, around the entire circumference of the refrigerant tube such that body material is forced radially inward toward the tube. The body material at least partially encloses the refrigerant tube bead within the counterbore to secure the
10 refrigerant tube to the valve body. A sharp edge between the counterbore and bore is forced against the junction between the bead and the refrigerant tube to provide a fluid tight seal.